

Work Order ID 59914

June 17, 2010 8:06:12 AM



Page 1

Item ID: D3179-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Litter Tie Down

Start Date: 18/06/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 25/06/2010 Req'd Qty: 4.00

Customer:

Reference:

10-06-17

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3179

Rev C

100

0.00



BAND SAW

0.00

ent 10/06/21

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks: 12.150" long

4

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

28 10/06/22

HAAS 1

Memo

HAAS CNC vertical machine #1

1- Mill as per Folio FA297 Rev: *AA* & Dwg D3179-1 Rev: *C* ☐ 2-Deburr
per dwg D3179-1

4

1

PTO

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

28 10/06/22

QC

Memo

Quality Control

4

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3179-041 PAR #: Fault Category: machining NCR: Yes No DQA: Date: 10-09
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 10-09

NCR: <u>59914</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/06/22	110	first part on 3 rd operation was off center by .100" R.L. operator error didn't take origin properly	<u> </u> JSLML	Replace batch # <u>57767</u> not acceptable scrap? <u>5</u>	<u> </u> 10/06/22	<u> </u> 10/06/22	<u> </u> JSLML	<u> </u> 10/06/22

NOTE: Date & initial all entries

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June 17, 2010 8:06:12 AM



Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 10/06/24

4

1

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml

10

06

24 (4)

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR

10-6-24

(4)

Work Order ID 59914

June 17, 2010 8:06:12 AM



Page 3

Item ID: D3179-041

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Item Name: Fwd Litter Tie Down

Stop



Start Date: 18/06/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 25/06/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:45

OVEN TEMPERATURE:

3200 FINISH TIME:

9:15

(H) BR 10-6-25

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MA 10 06 25 (4)

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3179

EP 10/06/28 (4)

Work Order ID 59914

June 17, 2010 8:06:12 AM



Page 4

Item ID: D3179-041

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Revision ID:

Item Name: Fwd Litter Tie Down

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Start Date: 18/06/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 25/06/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Swalobbs

24

200

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PC 10/6/29 (G)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29 J

W 10/6/29

Picklist Print

June 17, 2010 8:06:12 AM

Page 1

Work Order ID: 59914

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down




Start Date: 18/06/2010

Start Qty: 4.00

Required Date: 25/06/2010

Required Qty: 4.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP Rev:C 08-12-10 add part list DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2372  Quick Release		Manufactured	No			180	Each	10.0000	2	8			
<div> <div>Location</div> <div>ST012</div> <div>57765</div> </div> <div> <div>Loc Qty</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2444  Pip Pin Assembly		Manufactured	No			180	Each	3.0000	1	4			
<div> <div>Location</div> <div>ST014</div> <div>57766</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D6201  "T" Extrusion		Manufactured	No			180	f	26.6100	1.0125	4.263158			
<div> <div>Location</div> <div>MAT05</div> <div>56424</div> <div>57767</div> </div> <div> <div>Loc Qty</div> <div>26.61</div> <div>6.61</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

ES 10/06/28

8
ES 10/06/28
B60154 (2x)

4.263158" mkr 10/06/21
+ 1 parts scrap LB
10/06/22

Picklist Print

June 17, 2010 8:06:12 AM

Page 2

Work Order ID: 59914

Parent Item: D3179-041


Parent Item Name: Fwd Litter Tie Down

Start Date: 18/06/2010

Required Date: 25/06/2010


Start Qty: 4.00

Required Qty: 4.00

MS21042L3 Purchased No 180 Each 3,146.000 1 4

 Nut


Location	Loc Qty	Loc Code
ST300	3146	
113537	12	
113644	3	
114523	631	
114718	500	
114784	2000	

Ep 10/06/28

MS27039-1-13 Purchased No 180 Each 62.0000 1 4

 Screw

Location	Loc Qty	Loc Code
ST292	62	
110844	62	

Ep 10/06/28

NAS1149D0332J Purchased No 100 Each 771.0000 3 12

 Washer

Location	Loc Qty	Loc Code
FP	100	
113644	100	
ST298	671	
112794	15	
113237	58	
114348	198	
114884	400	

Ep 10/06/28

June 17, 2010 8:06:12 AM

Shop Packet Print

Page 2

DART AEROSPACE LTD		Work Order:	59914
Description: Fwd Litter Tie Down Bracket		Part Number:	D3179-1
Inspection Dwg: D3179	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.000	✓			
Ø0.242	+0.005/-0.001	.244	✓			
R0.40	+/-0.030	.400	✓			
0.375	+/-0.010	.365	✓			
Ø0.191	+0.005/-0.001	.194	✓			
1.00	+/-0.030	1.000	✓			
1.70	+/-0.030	1.624	✓			
4.00	+/-0.030	3.984	✓			
1.50	+/-0.030	1.500	✓			
0.750	+/-0.010	.751	✓			
1.50	+/-0.030	1.500	✓			
10.500	+/-0.010	10.500	✓			
4.250	+/-0.010	4.248	✓			
0.750	+/-0.010	.753	✓			
1.000	+/-0.010	.996	✓			
12.00	+/-0.030	12.000	✓			
1.00	+/-0.030	1.000	✓			
8.00	+/-0.030	8.000	✓			
Ø0.191	+0.005/-0.001	.194	✓			
R0.37	+/-0.030	.37	✓			
0.97	+/-0.030	.966	✓			
1.86	+/-0.030	1.355	✓			
1.750	+/-0.010				N/A	10.06.22
0.375	+/-0.010	.365	✓			
2.875	+/-0.010	2.374	✓			
0.500	+/-0.010	.501	✓			
1.250	+/-0.010	1.245	✓			
1.625	+/-0.010	1.622	✓			
3.31	+/-0.030	3.303	✓			

Measured by:	LF	Audited by:	SMF	Prototype Approval:	N/A
Date:	10/06/22	Date:	10/06/24	Date:	N/A

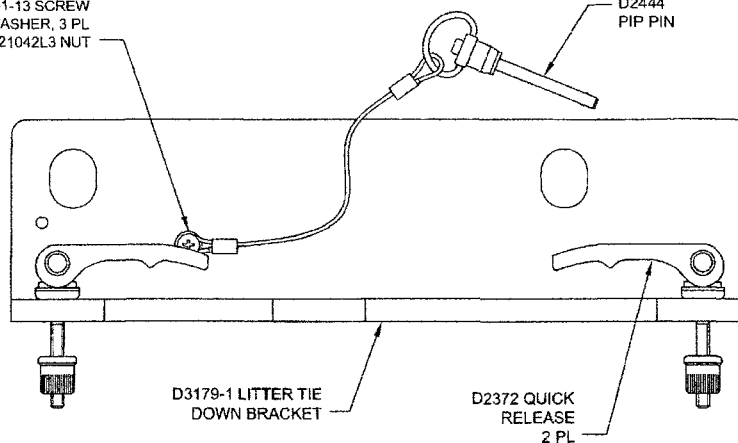
Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue	KJ/DD	AK

8 7 6 5 4 3 2 1

w/o 59914

MS27039-1-13 SCREW
NAS1149D0332J WASHER, 3 PL
MS21042L3 NUT

D2444
PIP PIN



D3179-041 FWD LITTER TIE DOWN BRACKET

Item	Qty	Part Number	Description
1	X	D3179-041	FWD LITTER TIE DOWN
2	2	D2372	QUICK RELEASE
3	1	D2444	PIP PIN
4	1	D3179-1	LITTER TIE DOWN BRACKET
5	1	MS21042L3	NUT
6	1	MS27039-1-13	SCREW
7	3	NAS1149D0332J	WASHER (OR AN960JD10L)

RELEASED
02/11/21

C	ADD D3179-041 & PART LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N	RF	08.11.07
B	REFORMAT DRAWING; FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV	DESCRIPTION	BY	DATE
DESIGN	BW		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

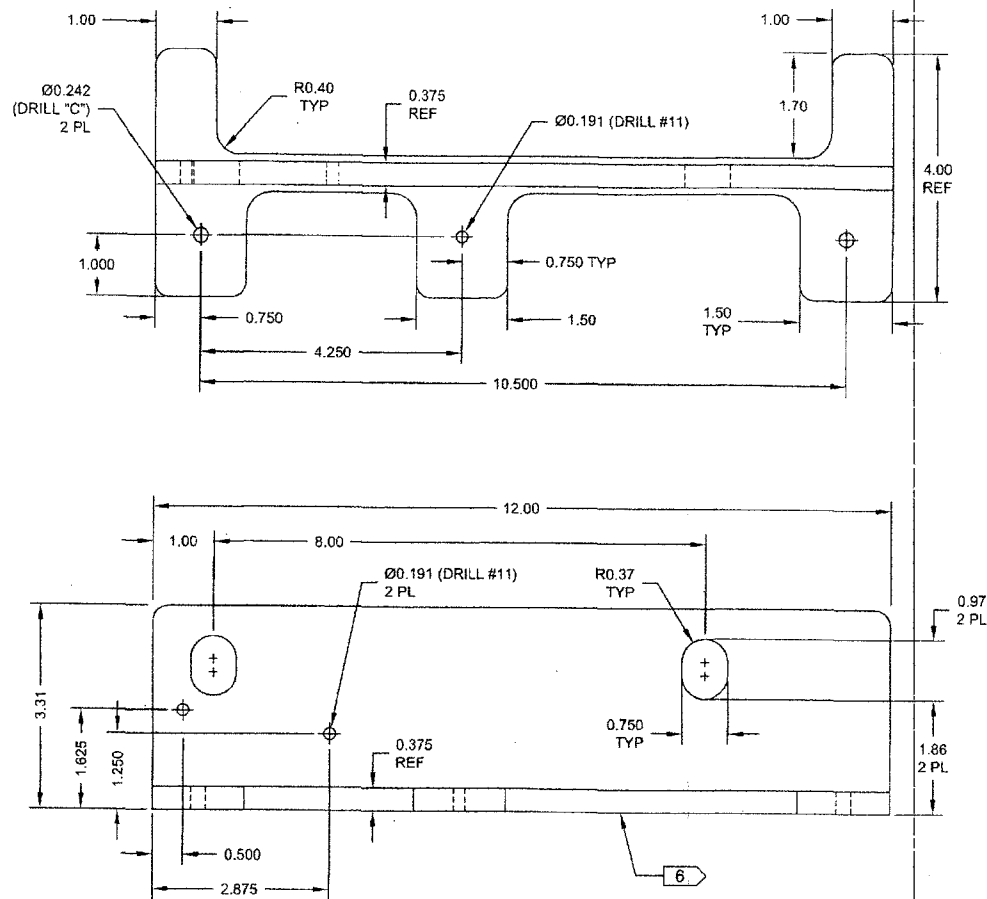
DRAWING NO. REV. C
D3179 SHEET 1 OF 2
TITLE SCALE
LITTER TIE DOWN BRACKET NTS

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NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON OR ENTITY

NOTES:
1) D3179-041 WEIGHT: 2.79 lbs

8 7 6 5 4 3 2 1

06/59914



D3179-1 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

RELEASED
08/11/07

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.		D3179	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND SHALL NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD</small>	